

Date: Wednesday, 30/07/2008 5:30:25 PM
 User: Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	AFT FACING SEAT ASS'Y LH
Job Number :	40822		
Estimate Number :	13306		
P.O. Number :		Part Number :	D412769043
This Issue :	30/07/2008	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D412-769-1 REVB
First Issue :	/ /	Project Number :	N/A
Previous Run :	40821	Drawing Revision :	B
		Material :	
Written By :		Due Date :	15/08/2008
Checked & Approved By :	JUD 08.7.31	Qty:	1 Um: Each
Comment :	Est rev A 08.05-12 new issue DD verified by:EC Est Rev:B 08-07-17 revB as per dwg DD verified by:ec		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1
 Pick Packing Kit

2.0	D3782045	Back Leg Assembly
-----	----------	-------------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
 Back Leg Assembly
 batch: B40873-3

FF 08/08/27

3.0	D3782041	Front Inboard Leg Assembly
-----	----------	----------------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
 Front Inboard Leg Assembly
 batch: B40870

SP

4.0	D3782043	Front Outboard Leg Assembly, LH
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
 Front Outboard Leg Assembly, LH
 batch: B40871

SP

5.0	D3783041	Lateral Brace Assembly
-----	----------	------------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
 Lateral Brace Assembly
 batch: B40874

8/8/2008

(1)

SP

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 30/07/2008 5:30:25 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT FACING SEAT ASSY LH

Job Number: 40822

Part Number: D412769043

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0	D3783043	Longitudinal Brace Assembly
-----	----------	-----------------------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Longitudinal Brace Assembly
batch: B40875

SP

7.0	D3783045	Angle Brace Assembly
-----	----------	----------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Angle Brace Assembly
batch: B40876

8.0	D3784041	Seat Support Assembly, Center
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Seat Support Assembly, Center
batch: B40877

SP

9.0	D3784043	Seat Support Assembly, LH
-----	----------	---------------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Seat Support Assembly, LH
batch: B40878

SP

10.0	D3784044	Seat Support Assembly, RH
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Seat Support Assembly, RH
batch: B40879

SP

11.0	D37661	Front Rail, LH
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Front Rail
batch: B40863

SP

12.0	D37663	Rear Rail
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Rear Rail
batch: B40865

8/8/08

(12)

SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT FACING SEAT ASSY LH

Job Number: 40822

Part Number: D412769043

Job Number:



Seq. #:	Machine Or Operation:	Description :
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13.0	D37671	Upper Rail
------	--------	------------

A



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Upper Rail
batch: B40866

14.0	D37921	Seat Belt Eye Bolt
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Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)
Seat Belt Eye Bolt
batch: B41521

SP

15.0	AN415A	Bolt
------	--------	------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Bolt
batch: M104746

SP

16.0	AN45 13A	EYE BOLT
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
EYE BOLT
batch: M109013

SP

17.0	AN510A	Bolt
------	--------	------



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)
Bolt
batch: M108471

SP

18.0	AN513A	Bolt
------	--------	------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Bolt
batch: M108167

8/8/27

SP

19.0	AN960JD10	Washer
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Comment: Qty.: 21.0000 Each(s)/Unit Total : 21.0000 Each(s)
Washer
batch: M109059
(or NAS1149D0363J) batch: M109059

*

FF 08/08/27

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT FACING SEAT ASS'Y LH

Job Number: 40822

Part Number: D412769043

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

AN960JD416

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Washer

batch: M108161

(or NAS1149D0463J) batch: _____

SP

21.0

AN960JD516

Washer



Comment: Qty.: 20.0000 Each(s)/Unit Total : 20.0000 Each(s)

Washer

batch: M108672

(or NAS1149D0568J) batch: _____

SP

22.0

AN52510R24

Screw



Comment: Qty.: 9.0000 Each(s)/Unit Total : 9.0000 Each(s)

Screw

batch: M108270

SP

23.0

MS21042L3

Nut



Comment: Qty.: 9.0000 Each(s)/Unit Total : 9.0000 Each(s)

Nut

batch: M108701

SP

24.0

MS21042L4

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Nut

batch: M107499

SP

25.0

MS21042L5

Nut



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Nut

batch: M108471

8/8/27

(12)

SP

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 30/07/2008 5:30:26 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT FACING SEAT ASSY LH

Job Number: 40822

Part Number: D412769043

Job Number:



Seq. #:

Machine Or Operation:

Description :

26.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- assemble as per dwg D412-769-1

FF 08/08/27

①

27.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/08/27

28.0

POWDER COATING

POWDER COATING



M106442



(X)

Comment: POWDER COATING

1- mask D3782-041 and D3782-043 front legs and D3787-1 foot as per dwg D412-769-041

2- Powder coat remaining of assembly grey as per dwg D412-769-1

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

10:15
320 OF
10:45

M-1 08/08/28

(P2)

29.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-08-28

(X)

30.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

31.0

D37751

Guard



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Guard

batch:

B40869


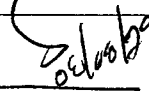


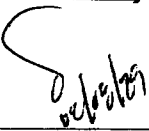
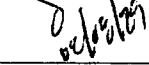



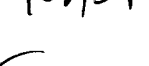

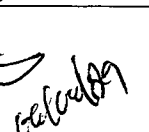
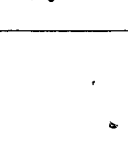
FF 08/08/29

①

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		add AW9603D 5/6 M108672 AMS-13A M108167 MS21042 LT M10847)					

Part No: D412-76043 PAR #: N/A Fault Category: Prod/Finishing NCR: Yes No DQA: A Date: 08/08/09
QA: N/C Closed: A Date: 08/08/09

NCR: <u>40822</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
8/6/09	1 28	Deeper inspection found a D3783-041 with a piece of masking tape that was power cutted over top of. R.C. tape was not removed before power cutting.		Remove piece of tape	M. H. 08/08/09			
				Scuff ental length at	M. H. 08/08/09			
				D3783-041 with 320 grit	M. H. 08/08/09			
				sand paper.	M. H. 08/08/09			
				Re powder coat as per	M. H. 08/09/09			
				QS2005	M. H. 08/09/09			
				Re inspect QC #3.				

NOTE: Date & initial all entries

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT FACING SEAT ASSY LH

Job Number: 40822

Part Number: D412769043

Job Number:



Seq. #:

Machine Or Operation:

Description :

32.0

D37741

Seat Bottom, LH/RH



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Seat Bottom, LH

batch: B40867

SB

33.0

D37743

Seat Back, LH/RH



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Seat Bottom, LH

batch: B40868

SB

34.0

AN525 10R22

Screw



Comment: Qty.: 13.0000 Each(s)/Unit Total : 13.0000 Each(s)

Screw

batch: B107936

SB

35.0

AN960JD10L

Washer



Comment: Qty.: 13.0000 Each(s)/Unit Total : 13.0000 Each(s)

Washer

batch: M105793

(or NAS1149D0332J) batch: _____

SB

36.0

MS21042L3

Nut



Comment: Qty.: 19.0000 Each(s)/Unit Total : 19.0000 Each(s)

Nut

batch: M108701

SB

37.0

AN35A

Bolt



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Bolt

batch: M100188

SB 08/08/29 (1)

38.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- install remaining parts as per dwg D412-769-1

FF 08/08/29 (1)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 30/07/2008 5:30:26 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT FACING SEAT ASS'Y LH

Job Number: 40822

Part Number: D412769043

Job Number:



Seq. #:

Machine Or Operation:

Description :

39.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

JS 08/08/29

40.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

Draft RPP. 40884

JS 08/08/29

41.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

JS 08/08/29

Job Completion



mf 08-08-29

Dart Aerospace Ltd

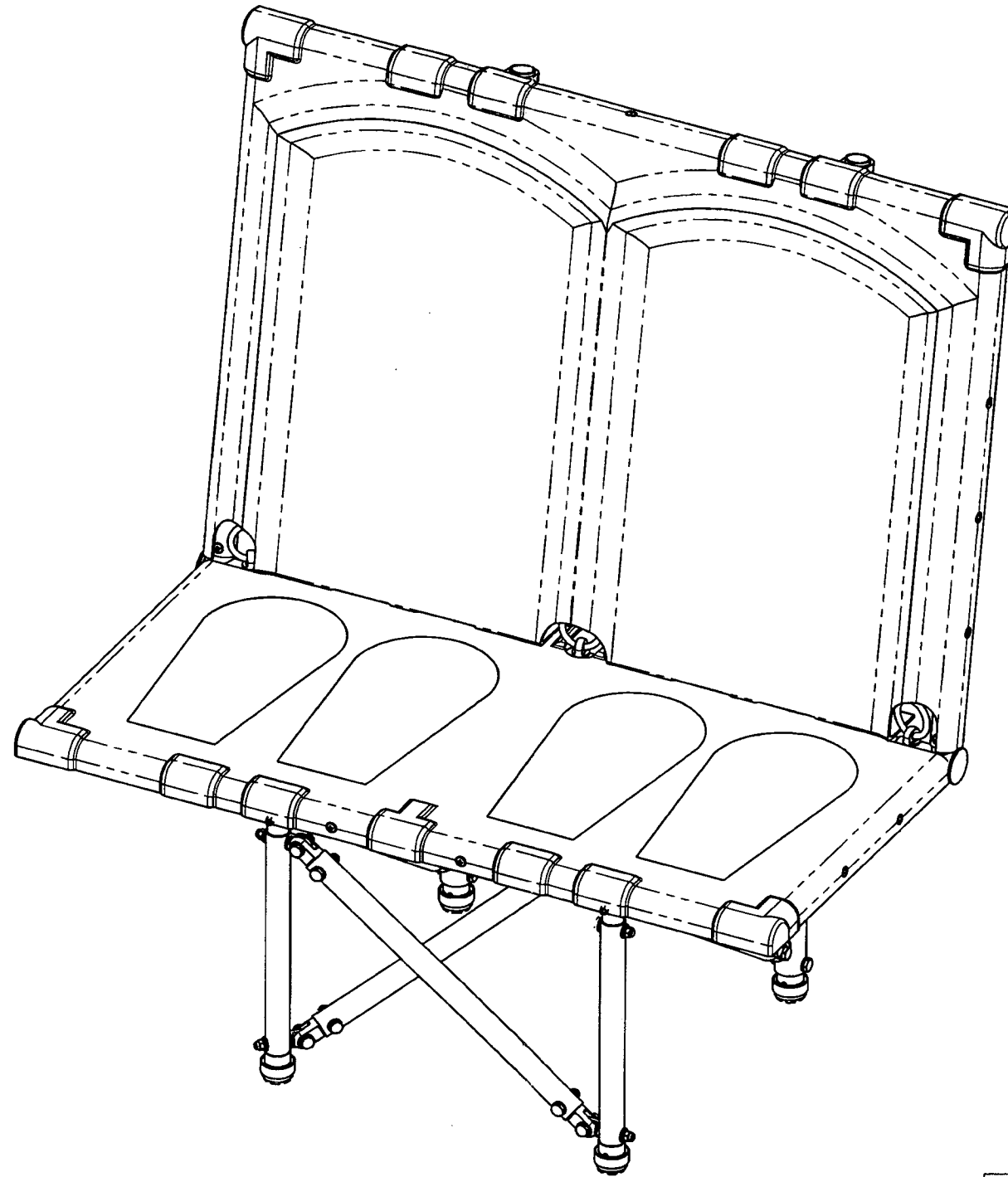
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D412-769-043 AFT FACING SEAT ASSY, LH

RELEASED
08.07.09

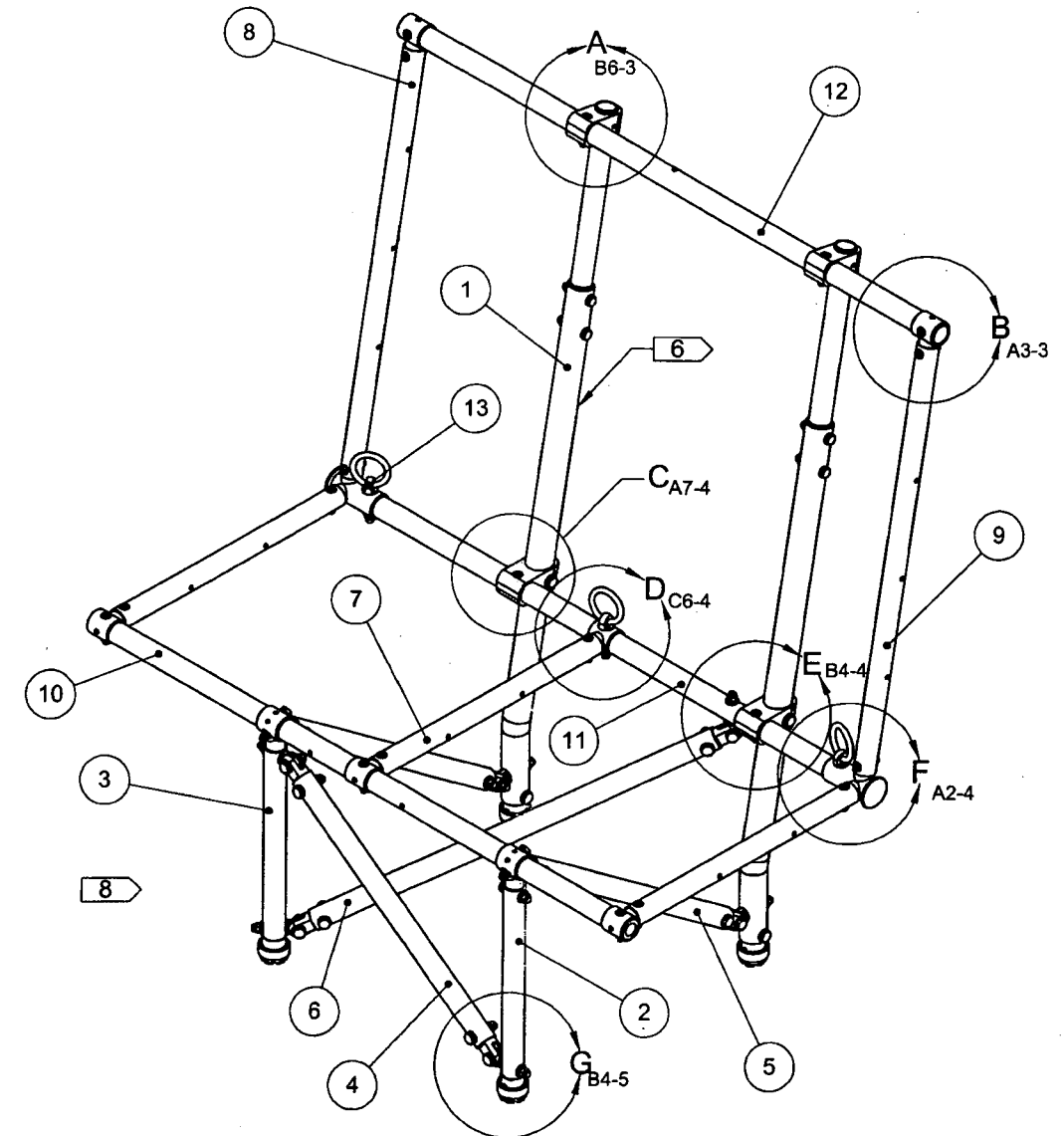
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WITHOUT NOTICE
WORK ORDER
NO. 40822

B	NEW HARDWARE	HS	08.06.25
A	NEW ISSUE	HS	08.06.04
REV.	DESCRIPTION	BY	DATE
DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	HS		
CHECKED	PA	DRAWING NO.	REV. B
MFG. APPR.	MA	D412-769-1	SHEET 1 OF 7
APPROVED	MA	TITLE	SCALE
DE APPR.	MA	AFT FACING SEAT ASSY, LH	NTS
DATE	08.06.25	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

ITEM NO.	PART NUMBER	DESCRIPTION	QTY. (-043)
1	D3782-045	BACK LEG ASSY	2
2	D3782-041	FRONT INBOARD LEG ASSY	1
3	D3782-043	FRONT OUTBOARD LEG ASSY, LH	1
4	D3783-041	LATERAL BRACE ASSY	1
5	D3783-043	LONGITUDINAL BRACE ASSY	2
6	D3783-045	ANGLE BRACE ASSY	1
7	D3784-041	SEAT SUPPORT ASSY	1
8	D3784-043	SEAT SUPPORT ASSY, LH	1
9	D3784-044	SEAT SUPPORT ASSY, RH	1
10	D3766-1	FRONT RAIL, LH	1
11	D3766-3	REAR RAIL	1
12	D3767-1	UPPER RAIL	1
13	D3792-1	SEAT BELT EYE BOLT	3
14	D3775-1	GUARD	2
15	D3774-1	SEAT BOTTOM	1
16	D3774-3	SEAT BACK	1
17	AN3-5A	BOLT	6
18	AN4-15A	BOLT	2
19	AN45-13A	EYE BOLT	1
20	AN5-10A	BOLT	6
21	AN5-13A	BOLT	2
22	AN525-10R22	SCREW	13
23	AN525-10R24	SCREW	9
24	MS21042L3	NUT	28
25	MS21042L4	NUT	2
26	MS21042L5	NUT	12
27	NAS1149D0332J	WASHER (AN960JD10L)	13
28	NAS1149D0363J	WASHER (AN960JD10)	21
29	NAS1149D0463J	WASHER (AN960JD416)	4
30	NAS1149D0568J	WASHER (AN960JD516)	20

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT ASSEMBLED SEAT "GREY SANDEX" (4.3.5.6) PER DART QSI 005 4.3 PRIOR TO INSTALLATION OF SEAT BOTTOM/BACK (D3774-1/-3). MASK FRONT LEGS PRIOR TO POWDER COAT.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH D2729-1 RED DECAL ATTACHED TO BACK LEG ASSEMBLY (D3782-045)
- 7) WEIGHT: 30.0 lbs
- 8) ITEM 15 (D3774-1 SEAT BOTTOM) AND ITEM 16 (D3774-3 SEAT BACK) REMOVED FOR CLARITY

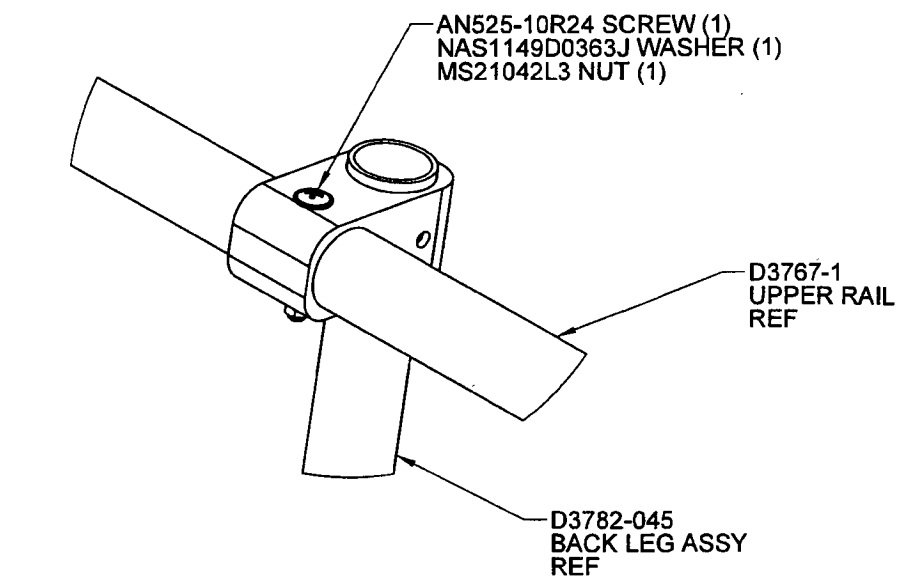


D412-769-043 AFT FACING SEAT ASSY, LH

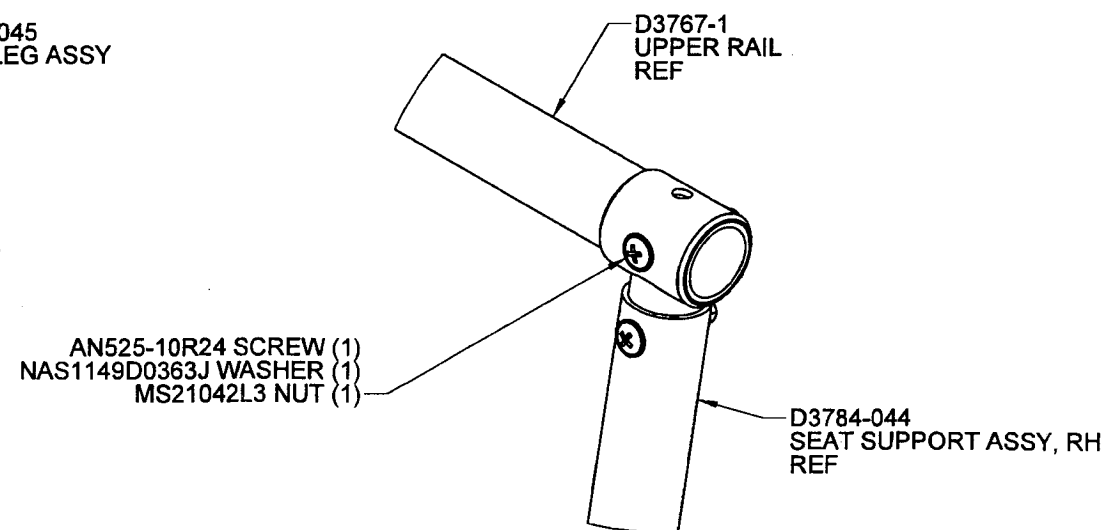
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08-07-09

DESIGN	HS	DART AEROSPACE LTD	
DRAWN	HS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D412-769-1	SHEET 2 OF 7
APPROVED		TITLE	SCALE
DE APPR.		AFT FACING SEAT ASSY, LH	NTS
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WORK ORDER
NO. 40822



DETAIL A D2-2
UPPER RAIL TO BACK LEG ATTACHMENT
2 PL



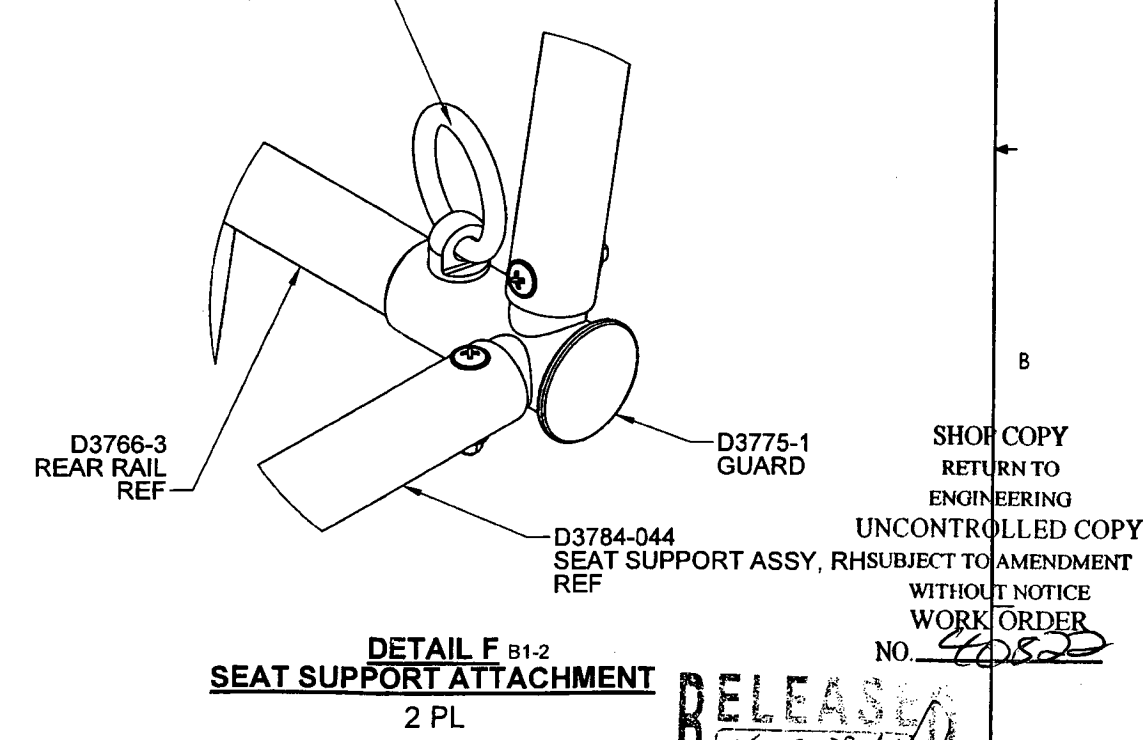
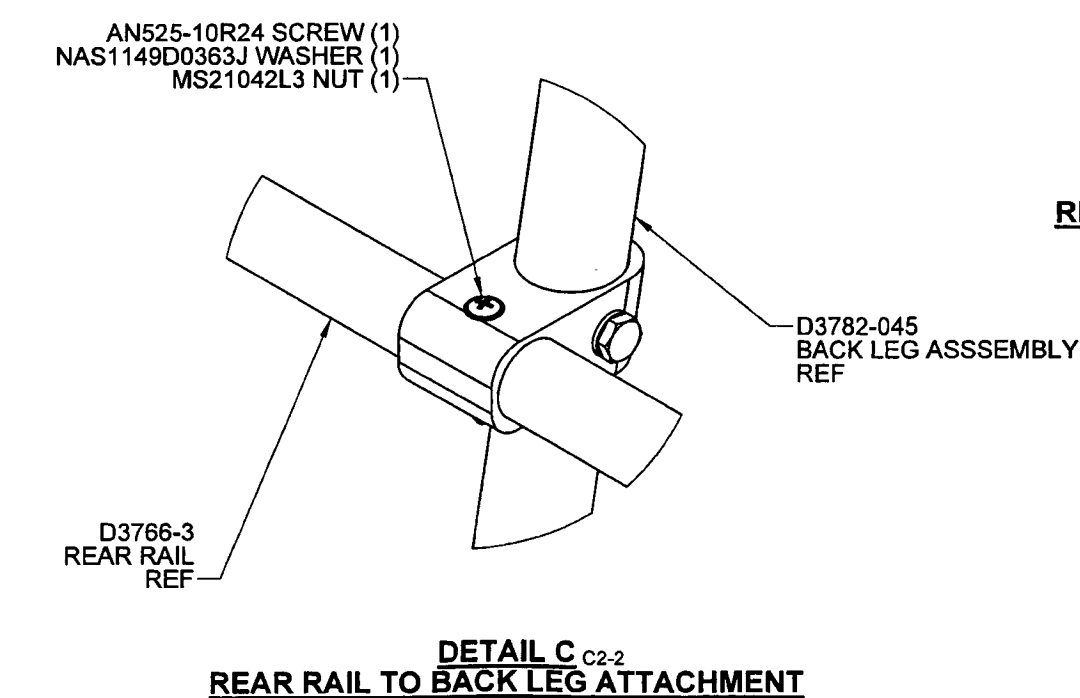
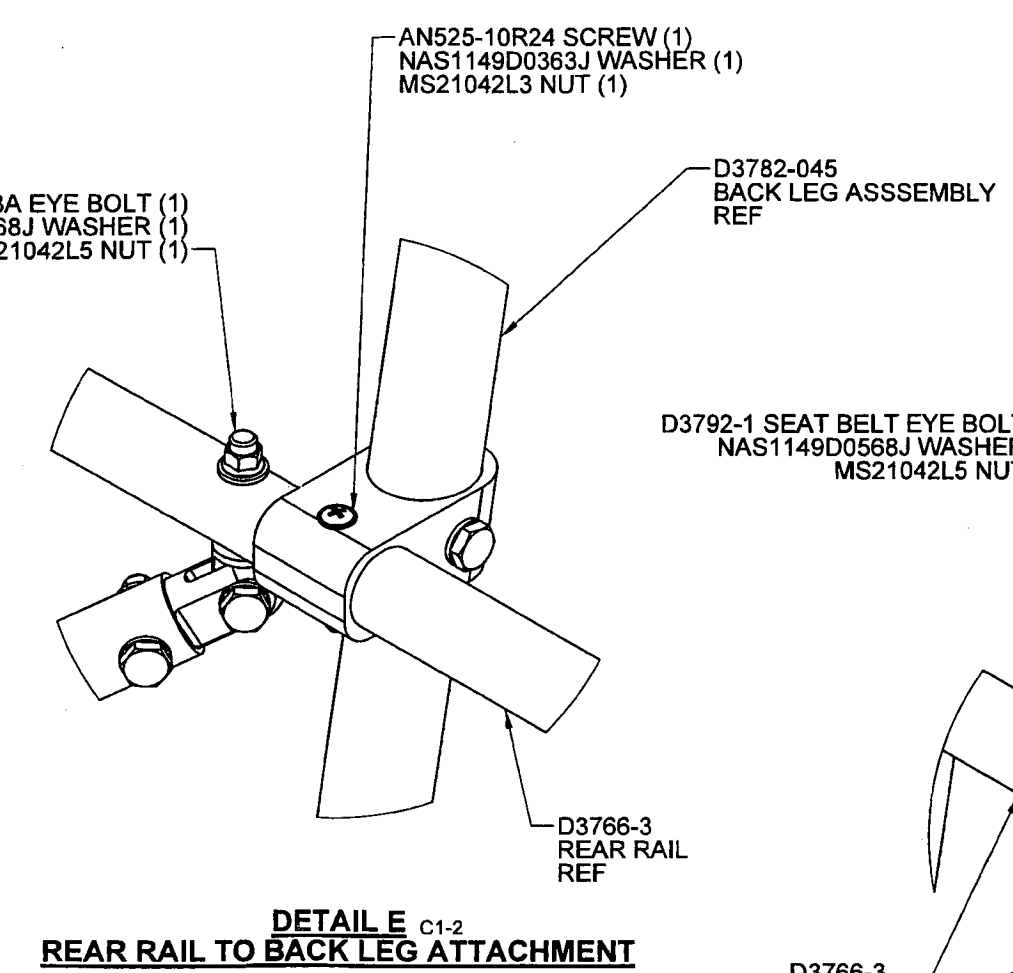
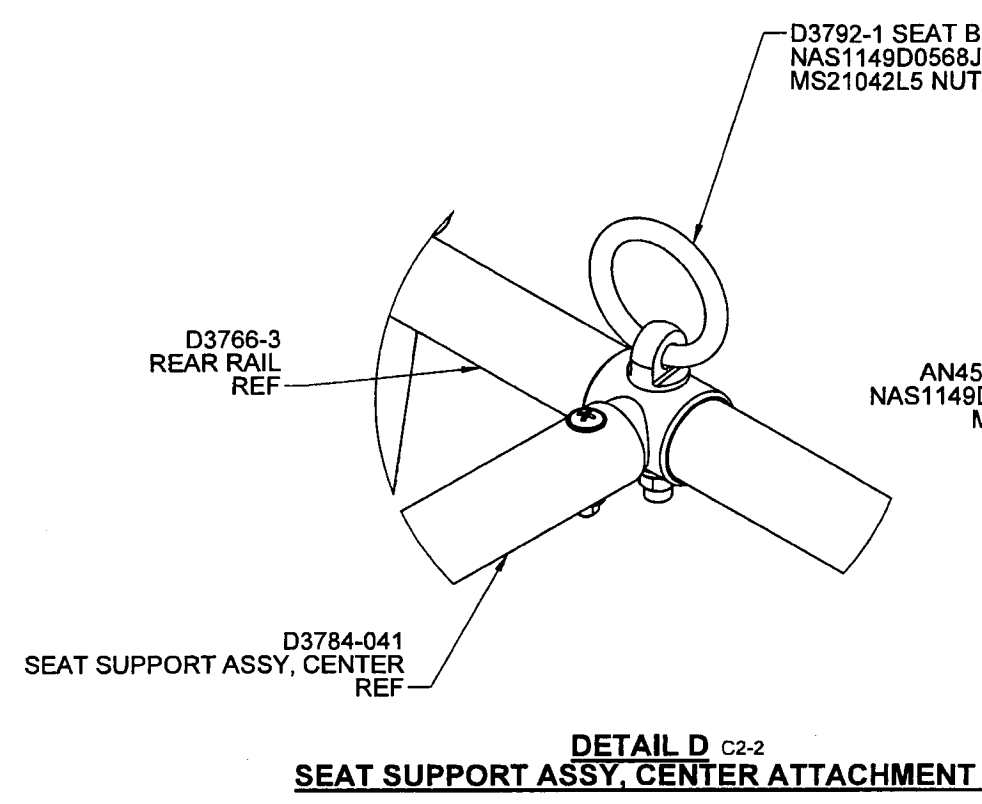
DETAIL B C1-2
SEAT SUPPORT END ATTACHMENT
5 PL

RELEASED
08.07.09

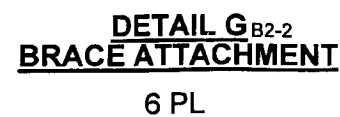
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WORK ORDER
NO. 40822

DESIGN	HS	DART AEROSPACE LTD	
DRAWN	HS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D412-769-1	SHEET 3 OF 7
APPROVED		TITLE	SCALE
DE APPR.		AFT FACING SEAT ASSY, LH	NTS
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8 7 6 5 4 3 2 1

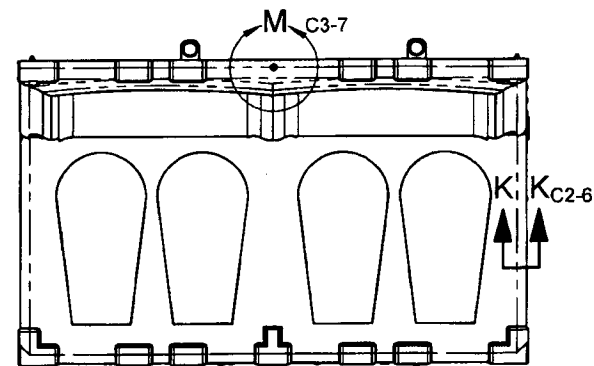


DESIGN	HS	DART AEROSPACE LTD	
DRAWN	HS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D412-769-1	SHEET 4 OF 7
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	AFT FACING SEAT ASSY, LH	NTS
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DE APPR.		
DATE 08.06.25		REV. B SHEET 5 OF 7



AN525-10R22 SCREW (1)
NAS1149D0332J WASHER (1)
MS21042L3 NUT (1)
3 PL PER SIDE

D3784-044
SEAT SUPPORT, RH
REF

AN525-10R22 SCREW (1)
NAS1149D0332J WASHER (1)
MS21042L3 NUT (1)
2 PL PER SIDE

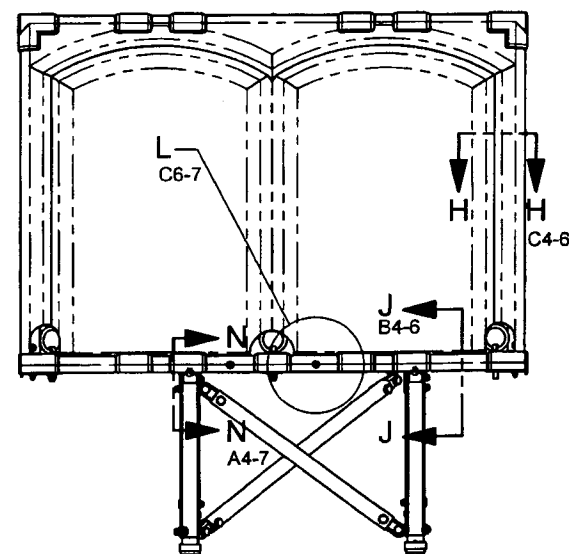
D3774-1
SEAT BOTTOM
REF

D3774-3
SEAT BACK
REF

D3784-044
SEAT SUPPORT, RH
REF

SECTION H-H B7-6

SECTION K-K D7-6



D3766-1
FRONT RAIL
REF

SECTION J-J A7-6

D3774-3
SEAT BACK
REF

D3774-1
SEAT BOTTOM
REF

D3766-3
REAR RAIL
REF

AN3-5A BOLT (1)
NAS1149D0363J WASHER (2)
MS21042L3 NUT (1)
6 PL

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- NOTES:**
1) TRANSFER DRILL $\varnothing 0.201$ FROM SEAT SUPPORTS (D3784-043/-044) TO SEAT BACK (D3774-3) - 3 PL/SIDE
2) TRANSFER DRILL $\varnothing 0.201$ FROM SEAT SUPPORTS (D3784-043/-044) TO SEAT BOTTOM (D3774-1) - 2 PL/SIDE
3) TRANSFER DRILL $\varnothing 0.201$ FROM SEAT BOTTOM (D3774-1) TO SEAT BACK (D3774-3) - 6 PL

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8

7

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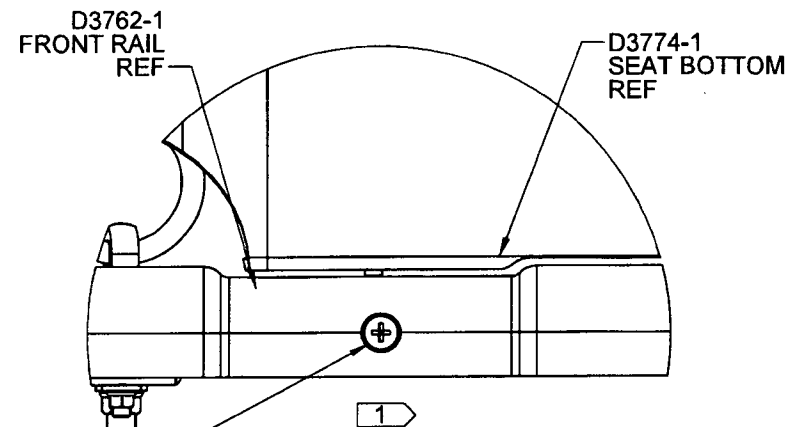
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3

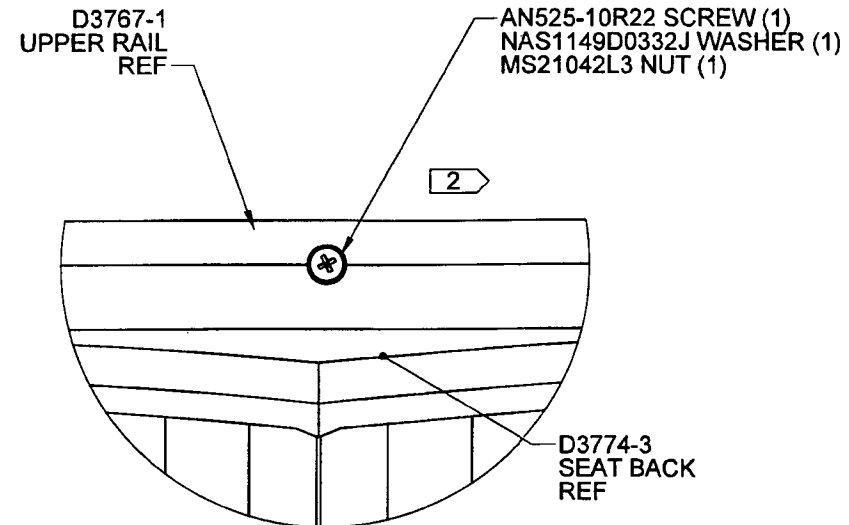
2

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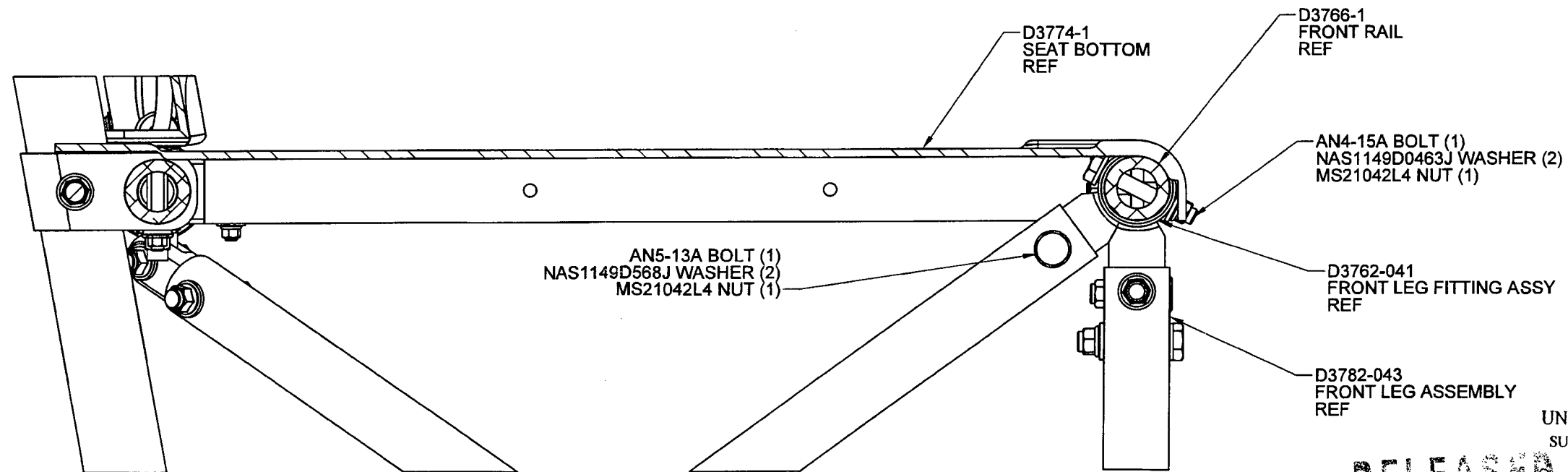


AN525-10R22 SCREW (1)
NAS1149D0332J WASHER (1)
MS21042L3 NUT (1)

DETAIL L A7-6
SEAT BOTTOM ATTACH - FRONT DETAIL
2 PL



DETAIL M D7-6
SEAT BACK ATTACH - TOP DETAIL



SECTION N-N A8-6
FRONT LEG AND LONGITUDINAL ANGLE ATTACHMENT
2 PL

NOTES:

- 1) TRANSFER DRILL $\varnothing 0.201$ FROM FRONT RAIL (D3766-1) TO SEAT BOTTOM (D3774-1) - 2 PL
2) TRANSFER DRILL $\varnothing 0.201$ FROM UPPER RAIL (D3767-1) TO SEAT BACK (D3774-3) - 1 PL

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